

ASAP

Work Order ID 74048

Wednesday, September 21, 2011 8:49:42 AM



~~PRELIMINARY ISSUE~~

Item ID: D3805-1

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 9/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3805	Revision Nbr <i>PB1 W B 11.10.04</i> <i>CEC 11-640</i>								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3805 Dwg Rev: <i>PB1</i> Prog Rev: <i>PB1</i> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

*B1-9-21*

*20*

*B1-9-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74048

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Page 2

Item ID: D3805-1

Accept

Revision ID:

Item Name: Plate

Start Date: 9/21/2011 Start Qty: 20.00

Required Date: 9/29/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00 - inspected to PBI



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

SB 11/09/22

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

- inspected to PBI

Dy only

SB 11/01/22

(420)  
count

20

W/O:		WORK ORDER CHANGES					
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Wednesday, September 21, 2011 8:49:42 AM

Page 3

Item ID: D3805-1

Accept

Revision ID:

Item Name: Plate

Start Date: 9/21/2011 Start Qty: 20.00

Required Date: 9/29/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: *W/A*

0.00

Packaging

Memo

0.00

Packaging

*EL 11-9-28* *(X20)*

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*n/10/4* *MF 11-09-28*

POSITIVE RECALL

DATE *11/9/21* AUTH *u*

DATE *11/10/09* ECN *11-640*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 21, 2011 8:49:39 AM

Page 1

Work Order ID: 74048

Parent Item: D3805-1

Parent Item Name: Plate



Start Date: 9/21/2011

Required Date: 9/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC  
IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC  
IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

205.5550

3.8542

81.14105

82.



304/316 .050 Sheet



1811-9-21

Location

Loc Qty

Loc Code

MAT020

64.655

113062

0.155

116979

64.5

MAT021

140.9

118217

140.9

118217

20

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**NOTE:** Date & initial all entries



7/10/18

☒ **First Article**      ☐ **Prototype**

PB1

Audited by:	S
Date:	11/09/22

→ PBI Dy only

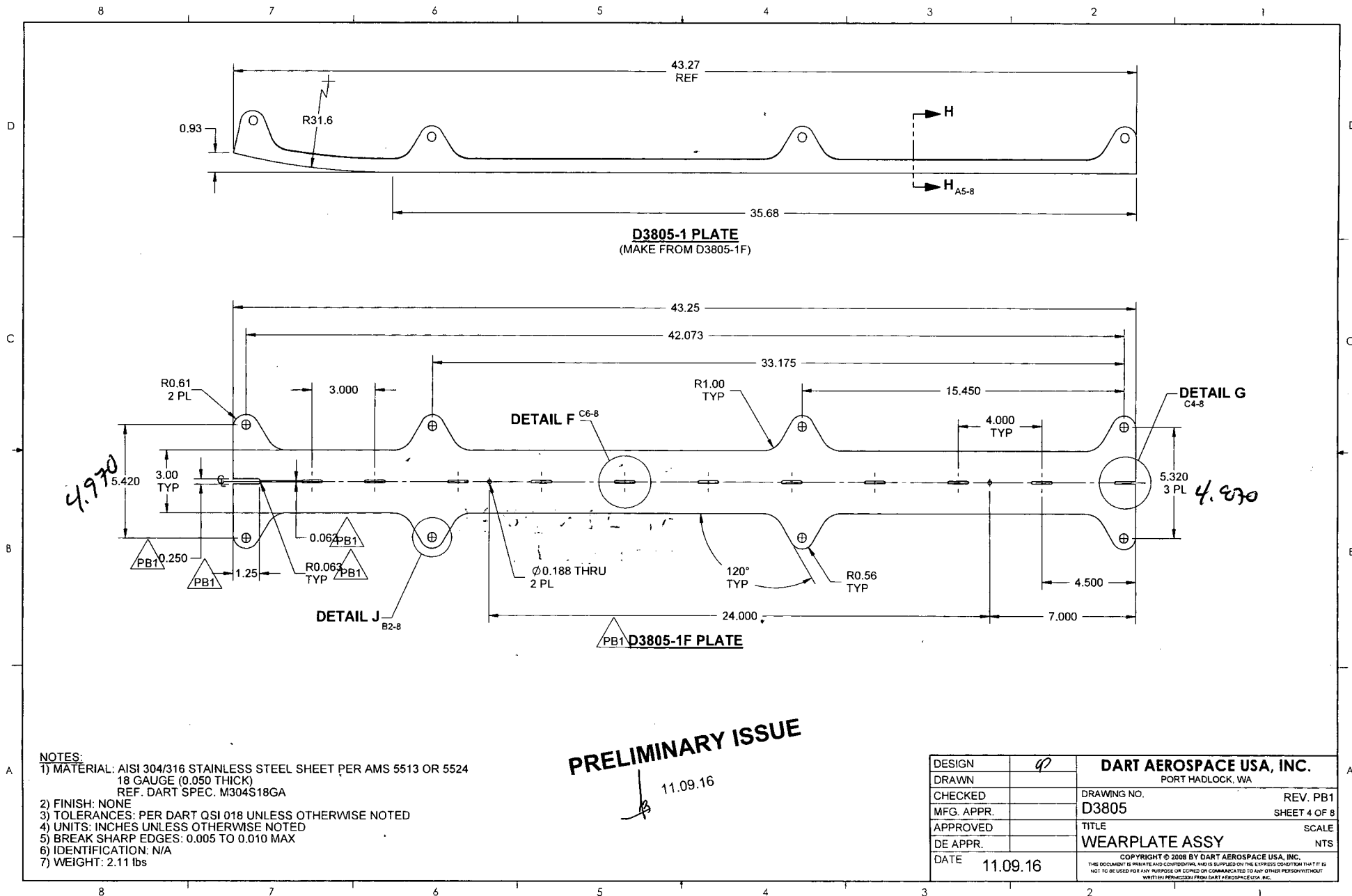
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

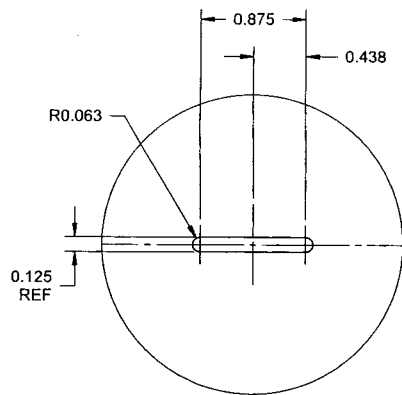
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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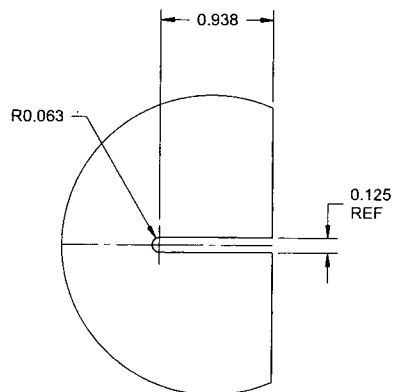
**NOTE:** Date & initial all entries





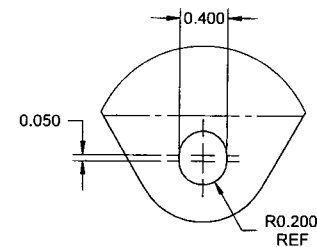
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SLOT DETAIL TYP  
SCALE 4X

C5-4  
C5-5  
C4-6  
C4-7



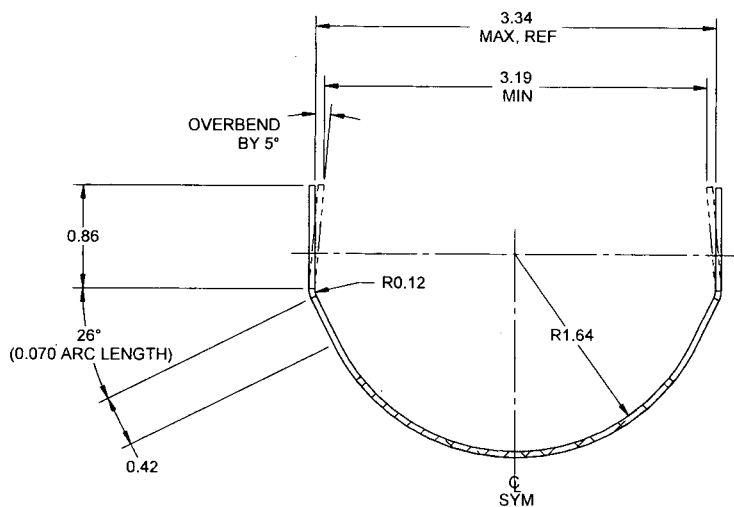
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SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B5-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

**PRELIMINARY ISSUE**

11.09.16

DESIGN	97	<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
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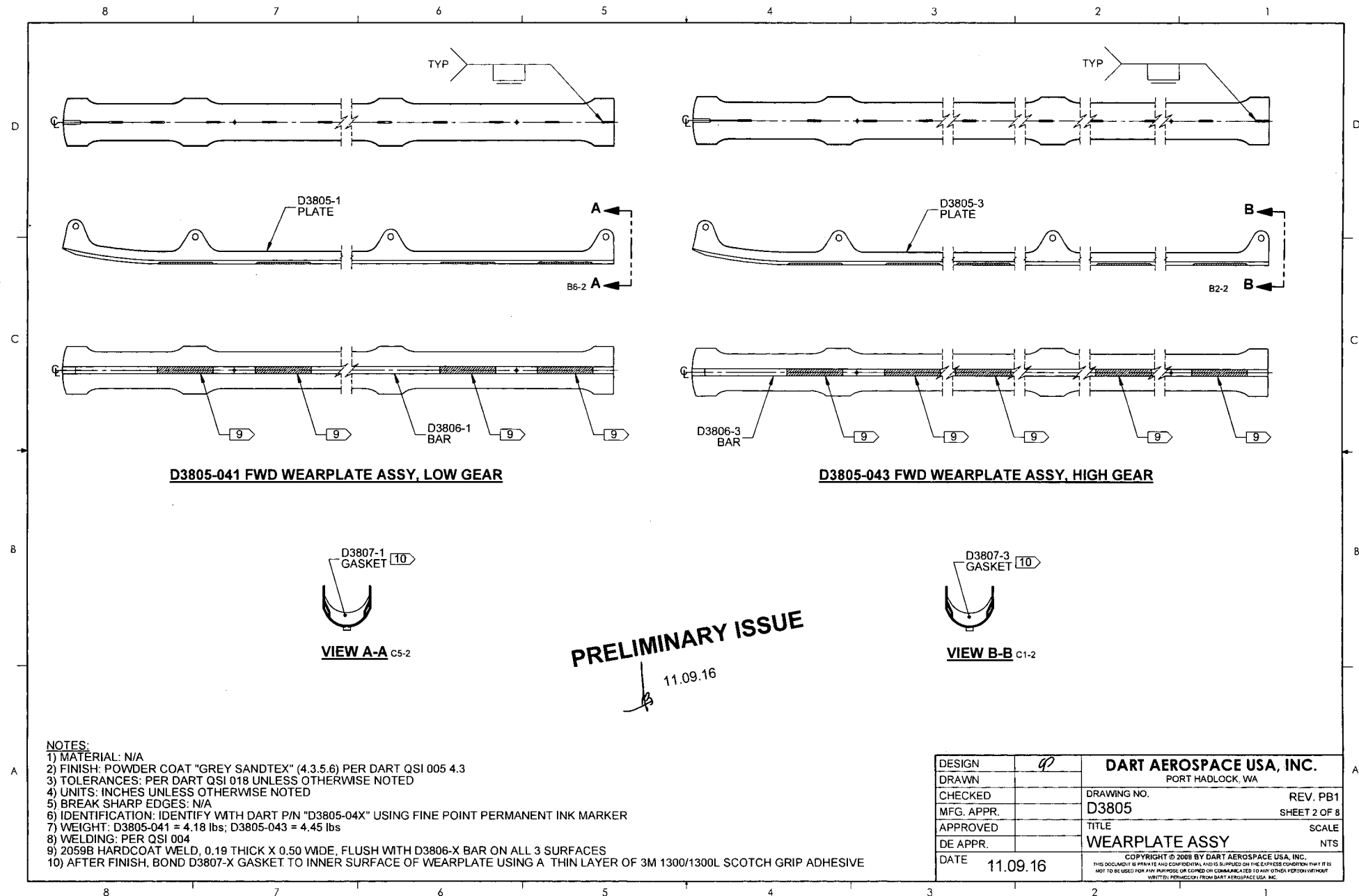
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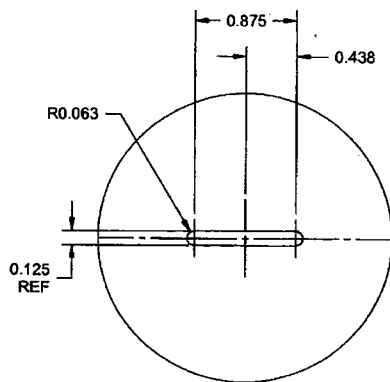
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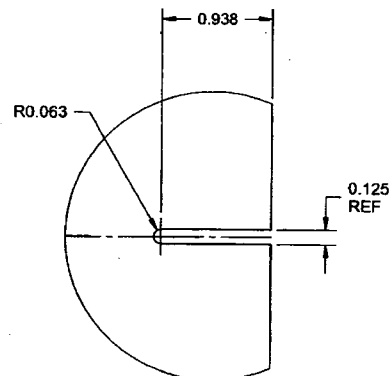
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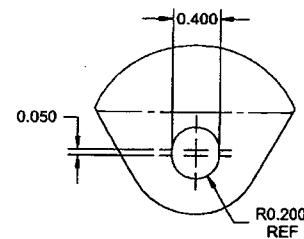




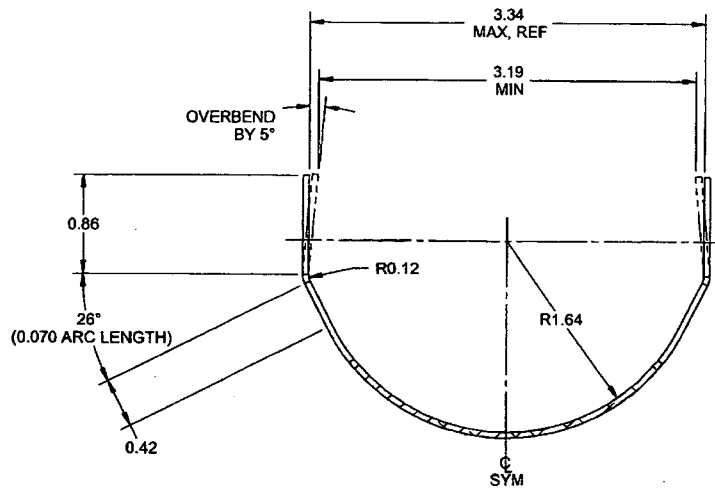
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SLOT DETAIL TYP  
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C5-4  
C5-5  
C4-6  
C4-7



**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X  
C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X  
B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X  
D3-4  
D3-5  
D3-6  
D3-7

**RELEASED**  
2011-10-03  
JW

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